

5/26

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23507</b>
<b>Description: Window Frame</b>	<b>Part Number:</b>	<b>D2956</b>
<b>Drawing: D2956 Rev. C</b>	<b>Qty:</b>	<b>50</b>

Stack of 20 RF 03.02.25

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	JA	05.06.06	50
2	METAL PG	Cut blanks: as per template DT8447 Material: 5052-H34 sheet 0.040" thick. Issue PO for D2956	u	05.06.07	50
3	HAAS RG	Machine as per folio FA036 Receive + inspect for transit damage	CD	05/06/09	50
4	QC 6	Inspect Level 6	2	05.07.04	50
5	METAL	Deburr if applicable	JA	05/07/07	50
6	METAL	Acid etch & Alodine	FF DL	05.07.07	50
7	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	FC	05.07.09	50
8	QC	Inspect Level 3	CD	05/08/03	50
9	STORES	Identify and stock	CD	05/08/03	50
10	EXPEDITING	Close W/O Cost / part 27.86 inspect Level 2.1	CD	05/08/09	50

Rev	Date	Change	Revised By	Approved
A	00.02.11	New Issue	EC	
B	00.03.07	Now goes on Haas	EC	
C	00.05.08	Removed P/O for powder coating, added acid etch step	EC	
D	01.06.14	Updated dwg to rev.C	EC	EC

RELEASED

EC 01.06.14

UNDER REVIEW

RF 03.02.21

INCORPORATED INTO  
D350-567-023

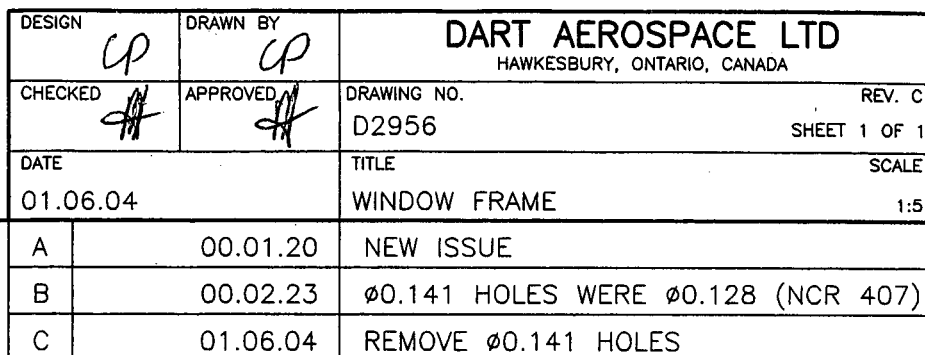
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

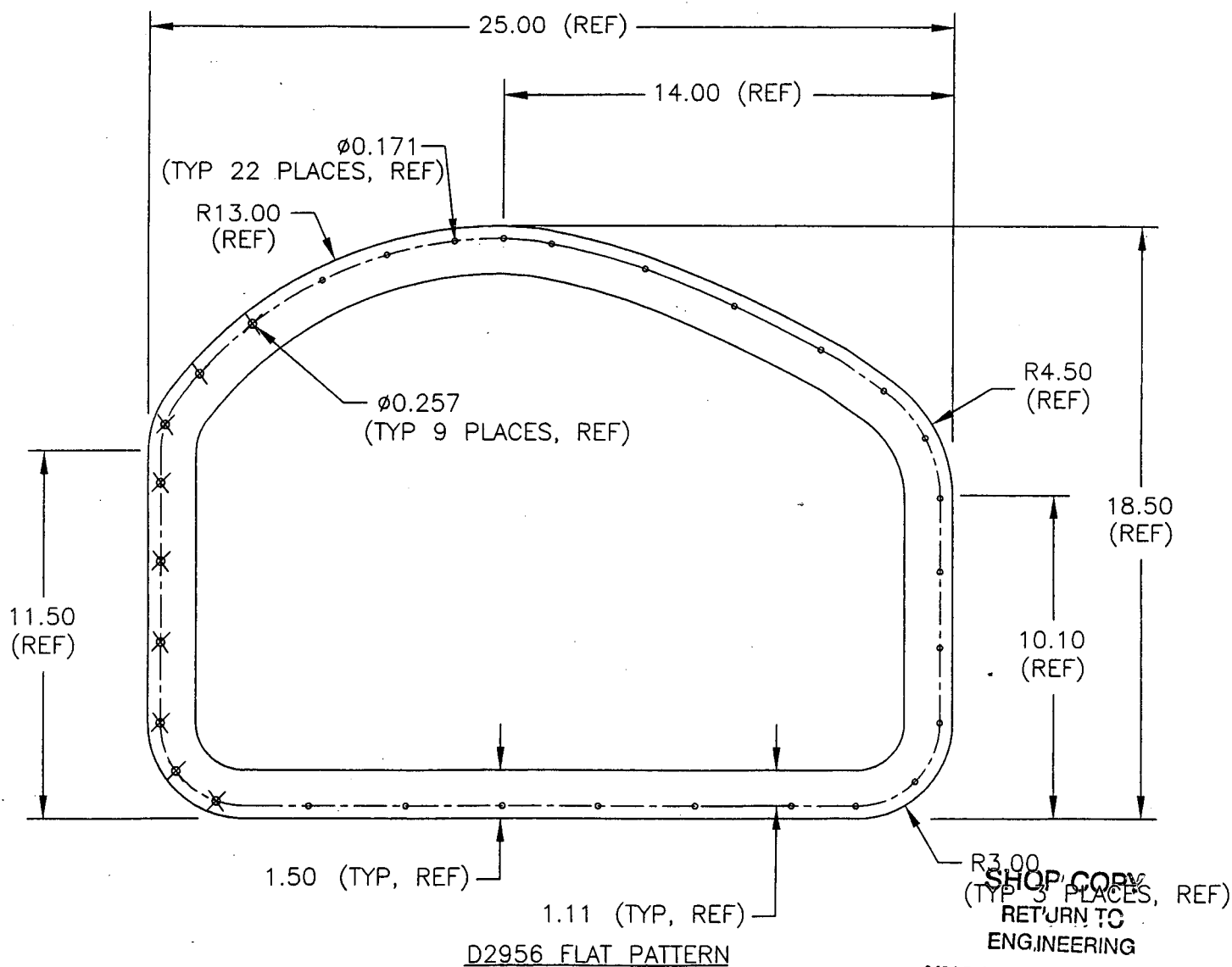
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LB Date: 05/08/24

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



RELEASED  
01.06.05



MACHINE PER DRAWING FILE "D2956-C1.DWG"  
CHECK HOLES PER TEMPLATE DT8437  
BEND PER TEMPLATE DT8567  
MATERIAL: 5052-H34 (QQ-A-250/8) SHEET 0.040 THICK  
FINISH: POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

# WORK ORDER

NO. 23507

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 06, 2005  
11:47 am

Work Order No : 0023507  
Project Name : D2956  
Project For : WK526  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2956  
Description : Window Frame  
Manufactured : Yes  
Amount Req'd : 50  
Amount Done : 0  
Start Date : 06-06-05  
Est Finish Date : 06-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. <u>1</u>		OUR JOB NO <u>J0129149</u>		SHIPPING MEMO <u>0307959</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
<u>50 PCS</u>	<u>2008171</u>	<u>D2956</u>	<u>C</u>	<u>WINDOW FRAM</u>	<u>C</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
<u>AL 5052-H32</u>		<u>CORUS ALUMINUM</u>		<u>1388651 ATT'D</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 27 JUNE 2005

G.F.I. Q.C. REP.





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2000 AS9100

### LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: 20 JUIN 2005

Company Name: G.F.I. Division of Thomas & Betts limited  
Address: 180 avenue Labrosse  
City: Pointe Claire, Qué.  
Zip Code: H9R 1A1

# du client: 0058953  
Customer's order #:

# de commande SSMQ: 842342  
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Gauge/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
4	9	.040" X 48" X 96"	5052 H32		1388651

Bien à vous,  
Yours truly,



Commis à l'administration.  
Administration Clerk.



DOC : V/0080134390

DATE : 2004-11-19

PROD. REF. : 0000166327

NR : 50914/01

PAGE : 1 / 1

INSPECTION CERTIFICATE



CUSTOMER : CORUS ALUMINIUM ROLLED PRODUCTS US

475 N. MARTINGALE ROAD, SUITE 400  
SCHAUMBURG 60173 USAYOUR ORDER NUMBER : P02731 (SAMUEL'S PO# A15790)  
OUR ORDER NUMBER : 50914/01  
DOCUMENT NUMBER : V/0080134390Corus Aluminium N.V.  
A. Stockelaert 87, 2570 Duffel - Belgium  
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 84DESCRIPTION : ALU SHRET 5052-H32 QQA-250/8 AMS 4016 ASTM B209  
DIMENSIONS : 96" X 48" X 0.04"  
ARTICLE NO. :COIL  
NUMBERCAST  
NUMBER

## CHEMICAL COMPOSITION (%)

		SI	FE	CU	MN	MG	CR	ZN
	MIN					2,2	0,15	
	MAX	0,25	0,40	0,10	0,10	2,8	0,35	0,10
002	1388651	0,12	0,26	0,01	0,09	2,5	0,16	0,01

OTHERS : EACH : MIN 0,05 MAX  
TOTAL : MIN 0,15 MAX

## MECHANICAL PROPERTIES

TEST-  
NUMBER1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI  
/A = REAR END /M = MIDDLE /V = FRONT END /O = RANDOM SAMPLING

		RM	RP02	A
		KSI	KSI	%
	MIN	31	23	5
	MAX	38		
002	/M	33	29	10

1) 282443  
444  
445HEAD OF LABORATORY,  
XAVIER SCHELTJENS

Corus Aluminium Rolled Products - Corus Aluminium Extrusions

05 TUE 14:24 FAX

0004/0004